



Dart Aerospace Ltd.
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D135-1027-243
Job Sheet R205419



Part No: D135-1027-243

Job Qty: 1 pcs

Part Name: H135/EC135 - AFT Crosstube - Mid Height



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/20

Job Tracking No:

Due Date: 1/15/20

Created By: Jennifer Renwick

Type: Rework

Description: Per ECN19-841

Note: D135-1027-243 REV.D CHG 002 IPP REV:A 17.09.08 NEW ISSUE DD VERF:DP IPP REV:B 17.10.24 AS PER DWG REV.B DD VERF:DP IPP REV:C 18.11.08 AS PER DWG REV.C DD VERF:JFS/IPP Rev.D 19.10.30 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
125	Rework - 1 - Startup	1 pcs	1/15/20	1/15/20	0.00	1.00	Crosstubes - 1		
							Crosstubes - 2		
							Crosstubes - 3		
							Crosstubes - 4		
130	QC 5	1 pcs	1/15/20	1/15/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
145	Rework - 2 - B4B	1 pcs	1/15/20	1/15/20	0.00	0.25	Spray Paint - 1 - B4B		
							Spray Paint - 2 - B4B		
							Spray Paint - 3 - B4B		
							Spray Paint - 4 - B4B		
150	QC 14	1 pcs	1/15/20	1/15/20	0.00	0.00	QC 14 - 15		
							QC 14 - 2		
							QC 14 - 34		



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Container No: S246125



Part: D135 - 1027 - 243

Job No: R205419

Serial No/Batch: S246125

Revision: D

Inspector:

Exp Date:

Instructions: TC STC SH18-49 Issue 1, FAA STC SR04276NY dated 18/11/21, E

DAS
JAN 09 2020 68
9-89

DAS
JAN 11 2020 41
9-89

1/9/2020

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	JAN 13 2020 68
				QC 14 - 40	9-89
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
170	Packaging 3-1 - Stock - B4B	1 pcs	1/15/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
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					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
175	DC - 1 - B4B	1 pcs	1/15/20	0.00 0.00	DC - 1 - B4B
					DC - 2 - B4B
180	QC 21 - SA	1 pcs	1/15/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 125 - 1-Drill extra holes as per ECN 19-841. ***Note*** Take extra care not to scratch spray paint. 2-Deburr blow out Descriptions: chips. 3-Touch up ALODINE. 130 - QC5- Inspect part completeness to step on W/O 145 - 1-Touch up spray paint-B _____ EXP. _____ Let cure as per QSI 005 2-Install D5739-1 plugs. 150 - (QC14- Inspect Spray Paint) _____ 170 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D135-1027-243					

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175 - Document Control - Photocopy bluefile and create labels as per PPP D135-1027-243 CHG002
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D135-1027-243	H135/EC135 - AFT Crosstube - Mid Height	1 pcs (1 ea)	125-Rework - 1 - Startup	<u>5199713</u>
D5739-1	Plug	2 pcs (2 ea)	145-Rework - 2 - B4B	<u>5231642</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
125-Rework - 1 - Startup	D135-1027-243	1	0	0
145-Rework - 2 - B4B	D5739-1	2	1,000	0

Part Specifications

Specifications could not be found.

Plex 1/9/20 10:56 AM Dart.Renwick.Jennifer



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Container No: S246125**Part: D135-1027-243****Job No: R205419****Serial No/Batch: S246125****Revision: D****Inspector:****Exp Date:****Instructions: TC STC SH18-49 Issue 1, FAA STC SR04276NY dated 16/11/21, E**

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	☐ Rework ☒ Scrap ☐ Use-as-is	☐ Skid-tube ☐ Machining ☐ Large Fab	☐ Cross tube ☐ Small Fab ☐ Finishing	☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging	☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		
Date: <u>20.01.13</u>	Sequence #: _____	QTY Affected: _____		MRB (QSI042) <u>1NSP</u> <u>12</u> <u>920.01.13</u>			
Description Work Order Deviation		Disposition					
<u>Drug cells for P/S 850 B-1/2, there is none available in the shop.</u>		<u>Acceptable to use P/S 850 B-2 rather than P/S 850 B-1/2</u>					
Completed By <u>920.01.09</u>		Lead hand / Supervisor					
QC / QA Coordinator							
Root Cause		FAULT CATEGORY					
☐ Operator	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong			
☐ Manufacturing Process	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance			
☐ Equip/Tooling	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing			
☐ Handling/Preservation	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish			
☐ Material	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing			
☐ Product Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread			
☐ Process Improvement	☐ Mislabelled	☐ Fit/Function	☐ Off-set/Set-up				
☐ Human Factors	Other/Details:						